

We claim:-

1. A method of producing hollow moldings in a tool carrier,  
5 comprising the steps of
  - (i) filling the starting components for producing the  
moldings into a mold (iv), which has a core (v) which  
defines the hollow space of the molding,  
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  - (ii) opening the mold (iv), the molding being securely held  
by the core (v),
  - (iii) removing the molding from the core (v),  
15the molding being removed from the core (v) outside the mold  
(iv), wherein the starting components for producing the  
moldings are filled into a mold (iv) which is provided with  
release agent and which has a core (v) which is attached to  
20 the base or to the cover, defines the hollow space of the  
molding and is connected to at least one further core (vi),  
which is located outside the mold (iv), the mold (iv) is  
closed, after opening of the mold (iv) the core (v) is moved  
upward or downward out of the mold (iv) defined by the outer  
25 walls, the core (v) is exchanged for the core (vi), which is  
not holding a molding, by a pivoting movement through 180°,  
the core (vi) is moved into the mold (iv), with the core (v)  
arriving in a position from which the moldings are stripped  
off the core (v), connected to the core (vi), when the core  
30 (vi) is removed from the mold (iv).
2. A method as claimed in claim 1, wherein the moldings are  
produced in a fixed-cycle line comprising at least 4 tool  
carriers.  
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3. A method as claimed in claim 1, wherein the tool carrier has  
at least two cores (v) and (vi), which are alternately  
introduced into the mold (iv).
- 40 4. A method as claimed in claim 1, wherein the moldings are  
based on thermoplastic materials, rubber and/or plastics  
produced from reactive starting components in the mold (iv).
5. A method as claimed in claim 1, wherein the starting  
45 components for producing the moldings comprise a reaction  
mixture containing (a) isocyanates and (b) compounds reactive

Drawing

to isocyanates, with which mixture cellular polyurethane elastomers are produced as moldings.

6. A method as claimed in claim 1, wherein the molding is removed from the core (v) 1 min to 60 min after the opening of the mold (iv).
7. A method as claimed in claim 1, wherein the molding is subjected to a setpoint/actual comparison outside the mold (iv) before removal from the core (v).
8. A method as claimed in claim 1, wherein the molding is processed outside the mold (iv) before removal from the core (v).
9. A tool for producing hollow moldings including at least one mold (iv) and at least two cores (v) and (vi), which determine the hollow space of the molded parts, wherein the cores (v) and (vi) can be alternately positioned in the mold (iv) and the cores (v) and (vi) are pivotably mounted, the common pivot axis lying parallel to the longitudinal axis of the cores and centrally between the cores (v) and (vi).
10. A tool as claimed in claim 9, wherein the cores (v) and (vi) are arranged such that they are aligned in parallel and movable parallel to the longitudinal axis of the cores.
11. A tool as claimed in claim 9, wherein the tool has a device with which the molding is stripped off the core (v).
12. A tool as claimed in claim 9, wherein the tool is arranged movably in a fixed-cycle line, which is preferably circulating and operated continuously, with a mixing head fixed in place in relation to the tool for filling the starting components for producing the moldings into the mold (iv).
13. A fixed-cycle line for producing moldings, wherein the fixed-cycle line has at least one tool as claimed in claim 9.